

DART AEROSPACE LTD	Work Order :	92480
	Description:	Disassemble
		Rosen
N3278-04/	Approval :	
		Page 1 of 1

Step	Location	Procedure	By	Date
1	PK	Remove from Stock		
		<u>Qty</u> <u>Part Number</u> <u>Description</u> <u>Batch</u>		
		2 D3278041 Support ss'y B21953B	u	05.02.16
2	PK	Return to Stock		
		<u>Qty</u> <u>Part Number</u> <u>Description</u> <u>Batch</u>		
		2 D3278-1 Support B21953	u	050217
		2 D3278-2 Support B21953		
		4 D2230-1 Clamp B21954		
		4 AN4-134 M1604		
		4 AN9100 J0416 M15020/M14312		
		4 M82042L4 M15020/M14764		
		4 M820426AD36 M15631		
		2 D3278-3 B21961/B21203		
3	GA	Reassemble		
		4 D2230-1 Clamp B21953D	SB	05/05/05
4	Stores	Identify & Stock 25 D3278-041 b22480	CD	05/05/05
				2
3	A/C	Cost/Part. 61.81		
4	DC	Close W/O 51.20	SA	05.05.05
		Inspect Level 21		
			K	05.04.05

**Linda Lacelle**

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**From:** "Siân Willems" <sianw@dartaero.com>  
**To:** "Linda Lacelle" <lindal@dartaero.com>  
**Cc:** "\*\*Peggy McDonald" <peggym@dartaero.com>; "Brigitte Golden" <brigitteg@dartaero.com>;  
"Danielle Bilodeau" <daniellb@dartaero.com>  
**Sent:** Wednesday, February 16, 2005 2:41 PM  
**Subject:** stock D2230-1

Linda,

we have qty. 4 D2230-1 Lugs on order with a customer. Can you please advise earliest possible delivery?

Sian

52

Spec

DART AEROSPACE LTD	Work Order:	21953
Description: Support Assembly	Part Number:	D3278-041
Dwg: D3278 Rev. A	Qty:	100

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg NOT REQUIRED <i>RF</i> 04.07.05	<i>KJ</i>	04.11.23	100
2	MV	Cut blanks: 2.00" x 1.00" x 2.550" long Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000) Identify for D3278-1	<i>M15545</i> Batch: <i>M16241</i>	<i>Er</i>	25/01/23 100
3	MV	Cut blanks: 2.00" x 1.00" x 2.550" long Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000) Identify for D3278-2	<i>m16241</i>	<i>Er</i>	25/01/23 100
4	MV	Machine D3278-1 as per Folio FA405 and Dwg D3278 Identify as D3278-1	<i>Er</i>	25/01/23	100
5	QC2	Inspect parts as they come off the CNC machine	<i>Er</i>	05/01/23	100
6	MV	Deburr and Tumble	<i>Er</i>	05/01/23	100
7	QC8	Second check	<i>ml</i>	05/01/23	100
8	MV	Machine D3278-2 as per Folio FA405 and Dwg D3278 Identify as D3278-2	<i>Er</i>	05/01/23	100
9	QC2	Inspect parts as they come off the CNC machine	<i>Er</i>	05/01/23	100
10	MV	Deburr and Tumble	<i>Er</i>	05/01/23	100
11	QC8	Second check	<i>ml</i>	05/01/23	100
12	FP	Acid etch and Alodine as per QSI 005 4.1	<i>ml</i>	05/01/23	100
13	QC5	Inspect work to Step 12	<i>ml</i>	05/01/23	100
14	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	<i>ml</i>	05/01/23	100
15	QC3	Inspect Powder Coat	<i>ml</i>	05/01/23	100
16	GA	Rivet spacers with support as per Dwg D3278. (Note: D3278-1/-2 are on BOM as material from Steps 2-3) Pick: Packing Kit	<i>2</i>	05.02.23	100
		Qty Part Number Description Batch			<i>95</i>
		1 D3278-1 Support <i>B21953</i>			
		1 D3278-2 Support <i>B21953</i>			
		1 D3278-3 Spacer <i>B21961</i> <i>B21203</i>			
		4 MS20426AD3-6 Rivet <i>m1563</i>			
17	QC5	Inspect work to Step 16	<i>ml</i>	05.02.23	100

PREFACE.

11/04.04.72

DART AEROSPACE LTD		Work Order:	21953
Description: Support Assembly		Part Number:	D3278-041
Dwg: D3278 Rev. A		Qty:	100

Page 2 of 2

Step	Location	Procedure	By	Date	Qty
18	GA	Assemble support as per Dwg D3278 <b>Pick: Packing Kit</b> Qty Part Number Description Batch 2 D2230-1 Clamp 21954 2 AN4-13A Bolt M16114 4 AN960JD416 Washer M15020 M1432 M15093 2 MS21042L4 Nut (or -4) M13272 M15020 <b>Identify as D3278-041</b> M14764			
19	QC5	Inspect work to Step 18			20502-0895
20	ST	Identify and Stock			CD 05/02/19 95
21	AC	Cost / part 30.03			5/1 05-02-16 95
22	DC	Close W/O 29.88 Inspect Level 21			1/1 05.02.16 95

Rev	Date	Change	Revised By	Approved
A	04.04.19	New issue	KJ/JLM	1/1 04.04.22

RELEASED

1/1 04.04.22